

ABSTRACT

The present invention provides a system for supplying a lubricant necessary for efficiently manufacturing high-quality seamless pipes or tubes in a piercing mill, an apparatus for manufacturing seamless pipes or tubes having the supply system, and seamless pipes or tubes manufacturing method. The system for supplying a lubricant has a storage tank of the lubricant, a plumbing extending from the storage tank to a position near disk rolls, a nozzle provided at the tip of the plumbing, a device for switching flow direction provided in some midpoint of the plumbing, a plumbing extending from the device for switching flow direction to the storage tank, and a device for releasing pressure in a plumbing, provided between the switching device and the nozzle.